

Work Order ID 98131

98131

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March-07-13 1:25:52 PM

Item ID: D119-646-241

Accept

N900040100

Setup Start ***NS1***

Revision ID: ~~001~~

Stop ***NS2***

Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 3/07/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/07/13 Req'd Qty: 1.00 ***1***

Customer:

Reference: REWORK - ECN13-534

Approvals: Process Plan: *ISA* Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3887	B(DEO)								
IIN-D119-646	B								
100		0.00							
100									
DC		0.00							
Document Control	Memo Photocopy bluefile & type labels per PPP D119-646-241 PER ECN13-534		CHG003						
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish		0.00							
Hand Finishing	Memo PULL FROM STOCK: 1 X D119-646-241 B91578 REMOVE FWD CAP, PUT ASIDE TO RE-INSTALL								

Cancelled

130371

W

98131

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N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Reference: REWORK - ECN13-534

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

130

0.00

130

Skidtubes

0.00

Skidtubes

Memo

COUNTERSINK FWD MOST HOLES TO
0.385 X 100DEG ON BOTH SIDES
PER DSI 9594
DEBURR

0.00

135

135

QC

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

190

190

HandFinish

0.00

Hand Finishing

Memo

- RE-ALODINE AFFECTED AREAS
- TOUCH UP WITH IMRON

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Item ID: D119-646-241

Accept

N900040100

Setup Start *NS1*

Revision ID: U/R

Stop *NS2*

Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Date: 3/07/13 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 3/07/13 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference: REWORK - ECN13-534

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

98131

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

260	Identify as per dwg & Stock Location:	0.00	
-----	---------------------------------------	------	--

260

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

RE-PACKAGE PER PPP USING NEW B/N
NEW LABELS AND DSI PAPERWORK REQ'D

QC21- Final Inspection - Work Order Release	0.00
---------------------------------------------	------

270

QC

Quality Control

Memo

0.00

Picklist Print

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Page 1

Work Order ID: 98131

Parent Item: D119-646-241

Start Date: 3/07/13

Required Date: 3/07/13

Parent Item Name: Replacement Skidtube STD w/ Training Wearplates

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
B-1)(ecn 12-675) DD verf:JLM

IPP REV B 12.11.05 (DEOD3887-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-646-241		Manufactured	No				Each	0.0000		1		9/5/78	
Replacement Skidtube STD w/ Training Wearplates													
MS24694-C52		Purchased	No				Each	192.0000		2			
Screw													

Location

Loc Qty

Loc Code

ST301

192

124291

92

124308

100

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-646 REV. B,
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-646 REV. 1 OR EARLIER,
REF. FAA STC SR02024SE

1.0 PURPOSE

The purpose of this DSI is to provide instructions for customers to modify the forward end of the D119-646-XXX skidtubes using the DSI 9594-011 Kit to make the skidtubes compatible with the Agusta ground handling wheels. One kit modifies 2 skidtubes. After CHG 001, portions of this modification may have been incorporated in production and therefore will not need to be incorporated in the field.

2.0 PROCEDURE

Modify the skidtubes as follows:

- 2.1 Rotate the D3407-041 Tow Ring to the vertical position as necessary.
- 2.2 Mark holes in the center ridge as shown in Figure 1. Drill through skidtube with Ø0.500" (12.7 mm drill), and countersunk to Ø0.650 x 100°, two places per side.
- 2.3 Remove and discard the hardware retaining the forward Cap. Countersink the existing holes to Ø0.385 x 100°.
- 2.4 Deburr holes. Touch up affected areas with chemical film material (Alodine 1200 or 1201) per MIL-C-5541.
- 2.5 Bond D2579 spacers into the Ø0.500 holes center in the skidtube using Magnobond 6398. Grind flush prior painting as shown in Figure 1.
- 2.6 Apply one coat of MIL-P-85582 or MIL-P-2337 primer and 2-3 coats of MIL-C-83285 polyurethane coat to match original finish.
- 2.7 Fasten the forward Cap using MS24694-C52 Screws. Seal threads with Proseal 890. Ensure that screw heads sit below skidtube surface
- 2.8 Repeat steps 2.1 to 2.7 for opposite skidtube.

3.0 PART LIST

Qty -011	PART NUMBER	DESCRIPTION
X	DSI 9594-011	FWD GROUND HANDLING SPACER KIT
4	D2579	CROSS BOLT SPACER
4	MS24694-C52	SCREW

4.0 WEIGHT AND BALANCE

This modification has negligible effect on weight and balance.

B	ADD INSTRUCTION TO REMOVE EXISTING CAP MOUNTING HARDWARE AND REPLACE WITH COUNTERSUNK SCREWS	DB	13.02.20
A	NEW ISSUE	RF	12.02.03
REV.	DESCRIPTION	BY	DATE
DESIGN DRAWN CHECKED MFG. APPR. APPROVED DE APPR. DATE	RF DB MB N/A 13.02.20	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. DSI 9594 TITLE FWD GROUND HANDLING SPACER KIT COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
		REV. B	SHEET 1 OF 2
		SCALE	NTS

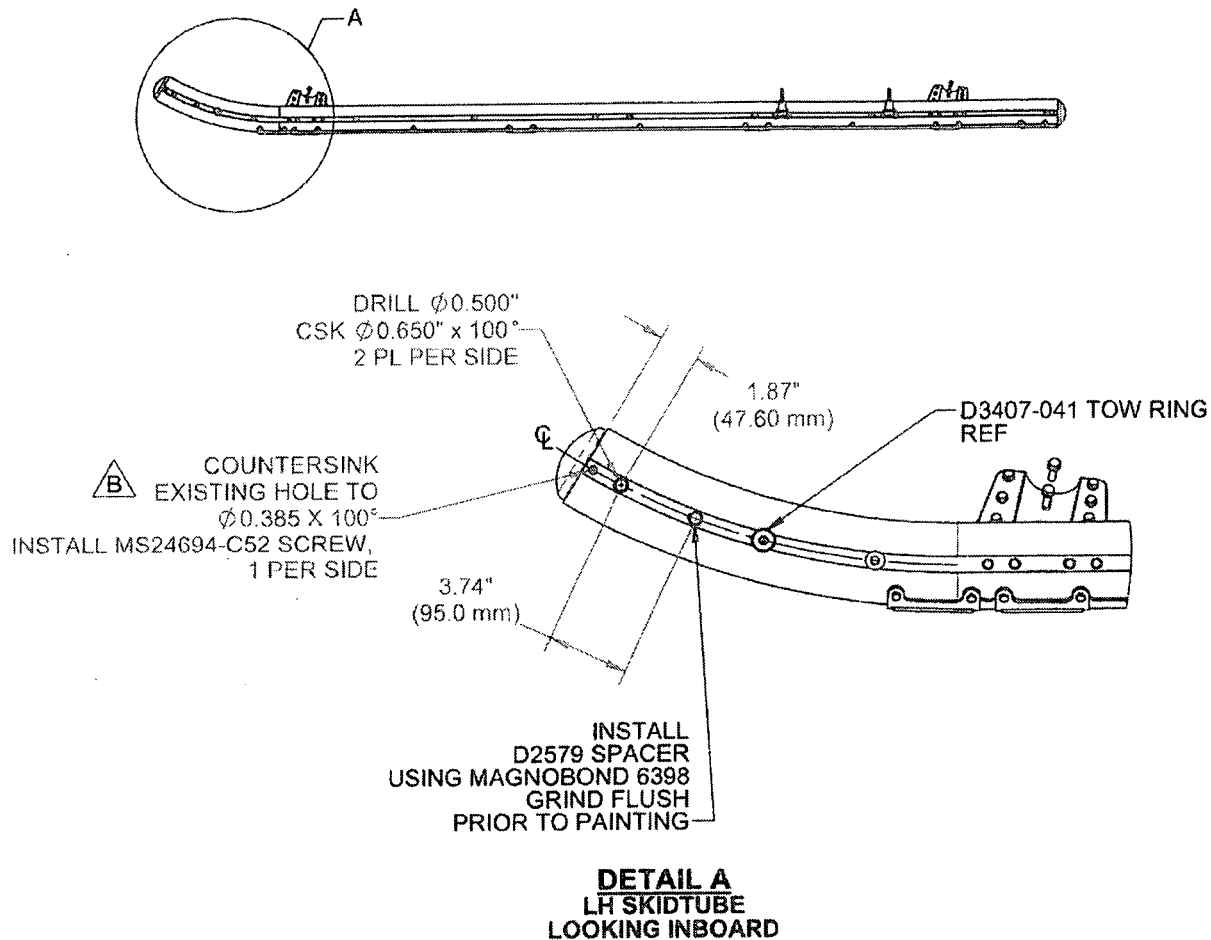


FIGURE 1. MODIFIED D119-646-XXX SKIDTUBE

DESIGN	RF
DRAWN	DB
CHECKED	MB
MFG. APPR.	N/A
APPROVED	<i>[Signature]</i>
DE APPR.	<i>[Signature]</i>
DATE	13.02.20

DART AEROSPACE USA, INC
KENT, WA

DRAWING NO.
DSI 9594

REV. B

SHEET 2 OF 2

TITLE
FWD GROUND HANDLING SPACER KIT

SCALE
NTS

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Linda Lacelle

From: Mike Petsche
Sent: March-06-13 10:27 AM
To: Linda Lacelle; David Shepherd
Cc: Eric Downing
Subject: RE: 119 skids

Yeah that's pretty much the gist of it. The DSI had been for A-W to do the mod for the aircraft that is here at the show. But for any stock/WIP you have, do exactly what you just said.

Dave (Bain) has updated the dwgs. An ECN should not be terribly far off. (I'm checking with him now to see where it is)

From: Linda Lacelle
Sent: Wednesday, March 06, 2013 7:36 AM
To: David Shepherd
Cc: Mike Petsche; Eric Downing
Subject: RE: 119 skids

Thx David. I'm a bit confused though, this DSI is for the customer when in the field correct? All we have to do is countersink the holes for the cap, re-alodine, touch up, replace cap with screw, correct?
LL

From: David Shepherd
Sent: March-05-13 2:32 AM
To: Mike Petsche; Linda Lacelle
Subject: RE: 119 skids

ECN 13-534

Linda,

I am good with modifying the front end of the 119 skid tubes to the attached DSI

Regards,
David

David

rework of

93/21 59

93/21 59